

Work Order ID 70757

Tuesday, June 14, 2011 1:20:54 PM



Page 1

Item ID: D205-633-017

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step, Standard Low Gear

Start Date: 6/14/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/17/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

DSI 90540

A

IIN-D205-633

B

100

0.00



DC

DOCUMENT CONTROL

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D205-633-017 CHG001/ DSI 9540

8/6/20

JG for BG 11-6-17

105

0.00



Test

Memo

0.00

Testing

PULL FROM STOCK:
1 X D205-633-017 B62773
FOR TRIAL FIT

PPG

DART Dart Aerospace Ltd. 1270 ABERDEEN ST. HAWKESBURY ONT CANADA K6A 1K7		TC APPROVAL # 09-89 TEL: 1-613-632-5200	
P/N	D205-633-017	CHG	CHG001
DESC	Heli-Access-Step	STC	SH96-57
LOT	B62773	STC	SR00592/3NY
MODEL	Bell 205/212/214/412	STC	SR00594NY
MADE IN CANADA		02729-1	

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Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

106

0.00



Powdercoat

Powder Coating

Memo

TOUCH UP A/R:

1 X D2563 62872

1 X D2562-007 B58620

1 X D2565-401 B58621

1 X D2565-403 B58622

1 X D2565-405 B58623

1 X D2565-407 B58624

1 X D2565-409 B37394

1 X D2565-411 B58625

0.00

Start Time: 1:10
Temp = 400°F
Finish Time: 1:40

7X ~~Ø~~ M. 14/06/16

107

QC3- Inspect Part Finish

0.00



QC

Quality Control

Memo

0.00

7 d M. 11/06/16

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Item ID: D205-633-017

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Setup Start



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Item Name: Heli-Access-Step, Standard Low Gear

Start Date: 6/14/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/17/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging	PICK NEW KIT PER ATTACHED PICKLIST								11/06/17
120 	QC4- 100% Inspect kits for completeness	0.00							
QC	Memo	0.00							
Quality Control									
130 	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	RE-PACKAGE PER PPP USING NEW B/N NEW PAPERWORK AND LABELS REQ'D								
	Identify and pack for shipping as per PPP D205-633-017/ DSI 9540								
	Location: _____								
	PPP Rev: _____								

REV B

CHG 001

Work Order ID 70757

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Tuesday, June 14, 2011 1:20:54 PM

Item ID: D205-633-017

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step, Standard Low Gear

Start Date: 6/14/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/17/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/21 JG
MF
11-06-21

Picklist Print

Page 1

Tuesday, June 14, 2011 1:20:51 PM

Work Order ID: 70757

Parent Item: D205-633-017

Parent Item Name: Heli-Access-Step, Standard Low Gear

Start Date: 6/14/2011

Required Date: 6/17/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 04.05.10 New Issue LKJ/JLM
11.01.12 AS PER DSI 9540 REV.A DD VERF:EC

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN4-14A		Purchased	No				Each	264.0000		1			
													
Bolt													

Location	Loc Qty	Loc Code
----------	---------	----------

ST357	254	
116914	4	
117619	100	
117872	150	
ST358	10	
117313	10	

AN4-5A		Purchased	No				Each	266.0000		2			
													
Bolt													

Location	Loc Qty	Loc Code
----------	---------	----------

ST355	200	
117508	200	
ST356	66	
116191	16	
116549	50	

g B C

117619

116191

11/06/11

Picklist Print

Tuesday, June 14, 2011 1:20:51 PM

Work Order ID: 70757

Parent Item: D205-633-017

Parent Item Name: Heli-Access-Step, Standard Low Gear

Start Date: 6/14/2011

Required Date: 6/17/2011

Start Qty: 1.00

Required Qty: 1.00

AN4-6A Purchased No Each 1,233.000 2 ✓
Bolt

Location	Loc Qty	Loc Code
ST356	1033	
115936	33	
116400	400	116400
116924	400	
117872	200	
ST358	200	
117514	200	

AN4-7A Purchased No Each 258.0000 2 ✓
Bolt

Location	Loc Qty	Loc Code
ST356	258	
115373	8	115373
117443	50	117443
117514	200	

AN5-14A Purchased No Each 79.0000 1 ✓
Bolt

Location	Loc Qty	Loc Code
ST338	79	
115374	79	115374

Picklist Print

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Parent Item: D205-633-017

Parent Item Name: Heli-Access-Step, Standard Low Gear

Start Date: 6/14/2011

Required Date: 6/17/2011

Start Qty: 1.00

Required Qty: 1.00

AN5-6A Purchased No Each 60.0000
Bolt

Location	Loc Qty	Loc Code
ST337	60	
117313	10	
117688	50	

1 ✓ JB L

AN960JD416 NAS1149D0463J Purchased No Each 0.0000
Washer

Location	Loc Qty	Loc Code
ST337	60	
117313	10	
117688	50	

15 ✓ 117313
117460 JB L

AN960JD516 NAS1149D0563J Purchased No Each 0.0000
Washer

Location	Loc Qty	Loc Code
ST337	60	
117313	10	
117688	50	

3 ✓ 117291 JB L

D2021-101 Manufactured No Each 35.0000
Eyebolt

Location	Loc Qty	Loc Code
ST337	60	
117313	10	
117688	50	

1 ✓ JB L

D2022-101 Manufactured No Each 112.0000
Spacer

Location	Loc Qty	Loc Code
ST004	35	
62464	5	
69527	30	

2 ✓ 62464
69532 JB 11/06/17

Location	Loc Qty	Loc Code
ST004	35	
62464	5	
69527	30	

Location	Loc Qty	Loc Code
ST504	112	
69532	52	
69824	60	

69532

Picklist Print

Tuesday, June 14, 2011 1:20:51 PM

Work Order ID: 70757

Parent Item: D205-633-017

Parent Item Name: Heli-Access-Step, Standard Low Gear

Start Date: 6/14/2011

Required Date: 6/17/2011

Start Qty: 1.00

Required Qty: 1.00

D2022-103
Spacer
Manufactured No

Each 45.0000

2

Location	Loc Qty	Loc Code
ST005	45	
47964	5	
69550	40	

47964

D205-633-017
Heli-Access-Step, Standard Low Gear
Manufactured No

Each 2.0000

1

Location	Loc Qty	Loc Code
FG070	2	
63150	2	

8

MS21042L4
Nut
Purchased No

Each 5,169.000

8

Location	Loc Qty	Loc Code
ST300	5169	
117441	2875	
117601	794	
117885	1500	

117441

MS21042L5
Nut
Purchased No

Each 1,048.000

2

Location	Loc Qty	Loc Code
ST300	1048	
116105	88	
116548	260	
117441	500	
117591	100	
117611	100	

116105

Linda Lacelle

From: Dan Stow <dstow@dartaero.com>
Sent: June 14, 2011 11:02 AM
To: L Lacelle
Subject: Trial fitted step

Hi Linda,

I trial fitted a 205 step and cannot return it to stock until the following has been done. How do I go about creating a work order for this?

D205-633-017 B62773 Trial fitted step.

Pick new hardware kit
Print new document package

Touch up:
D2563 step
D2562-007 strut
D2565-401 strut
D2565-403 strut
D2565-405 strut
D2565-407 strut
D2565-409 strut
D2565-411 strut

Dan Stow
Special Projects

Dart Aerospace Ltd.

Email: dstow@dartaero.com

Web: www.dartaero.com

P: 613.632.5200

C: 613.676.3320

F: 613.632.1426

Picklist Print

October 12, 2010 1:09:06 PM

Page 4

Work Order ID: 62773

Parent Item: D205-633-017

Parent Item Name: Heli-Access-Step, Standard Low Gear

Start Date: 10/08/10

Required Date: 10/15/10

Start Qty: 3.00

Required Qty: 3.00

D2562-007

Manufactured No

110

Each

5.0000



Strut

Location

Loc Qty

Loc Code

ST264

5

58620

5

Manufactured No

110

Each

0.0000

D2563

Step Weldment Assembly

D2565-401

Manufactured No

110

Each

4.0000



Strut

Location

Loc Qty

Loc Code

ST259

4

58621

4

Manufactured No

110

Each

4.0000

D2565-403



Strut

Location

Loc Qty

Loc Code

ST259

4

58622

4

Manufactured No

110

Each

4.0000

D2565-405



Strut

Location

Loc Qty

Loc Code

ST259

4

58623

4

October 12, 2010 1:09:06 PM

Shop Packet Print

Page 4

Picklist Print

October 12, 2010 1:09:06 PM

Page 5

Work Order ID: 62773

Parent Item: D205-633-017

Parent Item Name: Heli-Access-Step, Standard Low Gear

Start Date: 10/08/10

Required Date: 10/15/10

Start Qty: 3.00

Required Qty: 3.00

D2565-407

Manufactured No

110 Each

4.0000

1 13



Strut

Location

Loc Qty

Loc Code

ST259

4

58624

4

D2565-409

Manufactured No

110 Each

20.0000

1 13



Strut

Location

Loc Qty

Loc Code

ST259

20

37394

2

47831

10

47899

8

D2565-411-

Manufactured No

110 Each

4.0000

1 13



Strut

Location

Loc Qty

Loc Code

ST259

4

58625

4

MS21042L4

Purchased No

110 Each

4,050.000

8 24



Nut

Location

Loc Qty

Loc Code

ST300

4050

113422

68

114523

8

114718

16

114784

32

115108

926

115589

1900

115621

1100

October 12, 2010 1:09:06 PM

Shop Packet Print

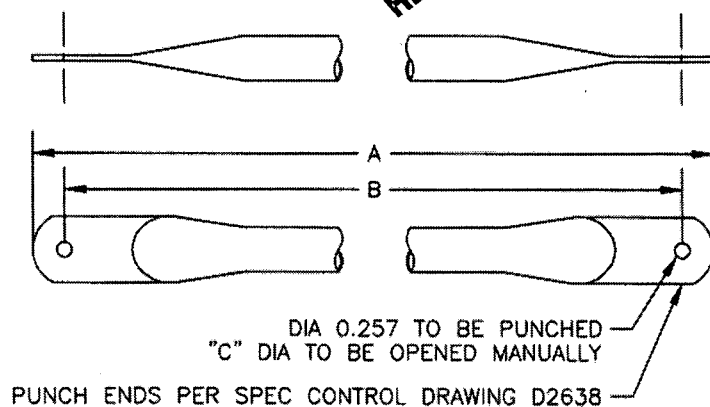
Page 5



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2565	REV. E SHEET 1 OF 1
DATE 04.05.05		TITLE STRUT	SCALE 1:3
A	96.05.03	NEW ISSUE	
B	97.03.15	CORRECT D2565-111 DIM. A	
C	98.10.05	UPDATED MATERIAL NOTE (TSR A603)	
D	02.06.05	ADD -3XX PARTS; ADD FINISH	
E	04.05.05	ADD D2565-401-411; RMV ANGLE D	

RELEASED
04.05.05

REFERENCE ONLY



PART #	A	B	DIA C
D2565-101	20.52	19.72	0.316
D2565-103	18.21	17.41	0.316
D2565-105	20.19	19.39	0.316
D2565-107	13.43	12.63	-
D2565-109	12.31	11.51	-
D2565-111	13.65	12.85	-
D2565-201	22.79	22.00	0.316
D2565-203	20.75	19.95	0.316
D2565-205	21.22	20.42	0.316
D2565-207	16.07	15.27	-
D2565-209	15.16	14.36	-
D2565-211	14.14	13.34	-
D2565-301	27.03	26.23	0.316
D2565-303	25.34	24.54	0.316
D2565-305	23.73	22.93	0.316
D2565-307	20.86	20.06	-
D2565-309	20.17	19.37	-
D2565-311	16.30	15.50	-
D2565-401	18.29	17.49	0.316
D2565-403	15.64	14.84	0.316
D2565-405	19.45	18.65	0.316
D2565-407	10.79	9.99	-
D2565-409	9.34	8.54	-
D2565-411	13.81	13.01	-

GENERAL NOTES

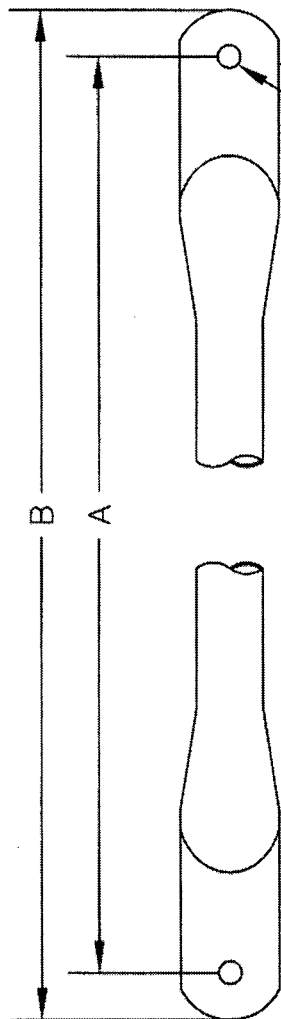
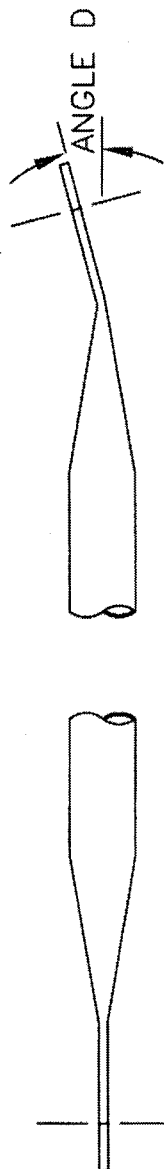
- 1) MATERIAL: AISI 304/316/318 SS 0.750 OD X 0.049 WALL
(REF DART SPEC. M304TR0.750W0.049)
ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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DESIGN CP	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2562	REV. D SHEET 1 OF 1
DATE 05.05.18	TITLE STRUT		SCALE 1:2
A	96.05.01	NEW ISSUE	
B	98.10.15	UPDATED MATERIAL NOTE (TSR A603)	
C	02.06.05	ADD -005; ADD FINISH	
D	05.05.18	ADD -007/-013; UPDATE -005	



"C" DIA TO BE OPENED MANUALLY

PUNCH ENDS PER SPEC CONTROL DRAWING D2727

REFERENCE ONLY

PART #	DIM A	DIM B	DIA C	ANG D
D2562-001	19.68	20.48	-	10
D2562-003	20.37	21.17	-	18
D2562-005	29.00	29.80	-	30
D2562-007	19.22	20.02	-	0
D2562-011	25.79	26.59	-	16
D2562-013	26.63	27.43	-	24

RELEASED

05.05.27

GENERAL NOTES

- 1) MATERIAL: AISI 304/316/318 SS 0.500 OD X 0.035 WALL (REF DART SPEC. M304TR0.500W.035) ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
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